

WHAT IS CLAIMED IS:

1. In a method for making a glittering cube corner sheeting, which method comprises:

5 providing a first sheeting having cube corner elements arranged thereon
 in an arrangement that does not give rise to a glittering
 appearance; and

 exposing the first sheeting to heat, pressure, or a combination thereof to
 produce a second sheeting in which the cube corner elements are
10 rearranged to give the second sheeting a glittering appearance;

the improvement wherein the exposing step comprises:

 passing the first sheeting through an extended heated zone;
 applying pressure to the first sheeting after it has been heated in the
 extended heated zone; and
15 supporting the first sheeting with at least one belt during the passing and
 applying steps.

2. The method of claim 1, wherein the first sheeting is provided from an unwind
roll and the second sheeting is collected on a take-up roll, the first and second
20 sheetings being part of a continuous length of cube corner sheeting material.

3. The method of claim 1, wherein the first sheeting comprises a film that
carries the cube corner elements, the film having a softening temperature lower
than that of the cube corner elements, and wherein the extended heated zone
25 exposes the first sheeting to a temperature T_{MAX} at or above the softening
temperature of the film but below the softening temperature of the cube corner
elements.

4. The method of claim 1; wherein the first sheeting has a sheeting width and
30 the extended heated zone has a length L in the direction of travel of the first
sheeting that is at least as great as the sheeting width.

5. The method of claim 1, wherein the extended heated zone has a length L sufficiently great so that the first sheeting has a dwell time in the extended heated zone of at least about 20 seconds.

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6. The method of claim 5, wherein the first sheeting passes through the extended heated zone at a speed of at least about 15 feet per minute.

7. The method of claim 1, wherein the second sheeting is formed by the
10 applying pressure step, the method further comprising:

providing a cooling zone;

passing the second sheeting through the cooling zone; and

supporting the second sheeting with the at least one belt as the second
sheeting is passed through the cooling zone.

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8. The method of claim 7, wherein the pressure is applied to the first sheeting by passing the first sheeting through a nip formed by at least one roller, the method further comprising:

contacting the first sheeting with a textured material at least at the nip;

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and

separating the textured material from the second sheeting downweb of the cooling zone.

9. The method of claim 8, wherein the at least one belt is included in a pair of
25 endless belts that carry the first sheeting and the textured material through the extended heated zone and the nip, and that carry the second sheeting and the textured material through the cooling zone.

10. The method of claim 1, wherein the at least one belt is included in a pair of
30 endless belts that carry the first sheeting through the extended heated zone.

11. The method of claim 10, wherein the at least one belt contacts at least one heating element in the extended heated zone.

12. The method of claim 11, wherein heating elements are provided on both
5 sides of the first sheeting in the extended heated zone.

13. In a method for making a glittering cube corner sheeting, which method comprises:

10 providing a first sheeting having cube corner elements arranged thereon
in an arrangement that does not give rise to a glittering
appearance; and

exposing the first sheeting to heat, pressure, or a combination thereof to
produce a second sheeting in which the cube corner elements are
rearranged to give the second sheeting a glittering appearance;

15 the improvement wherein the exposing step comprises:

passing the first sheeting through an extended heated zone;

passing the first sheeting through a nip formed by at least one roller after
the first sheeting has been heated in the extended heated zone; and

20 supporting the first sheeting with at least one belt during the two passing
steps.

14. The method of claim 13, wherein the extended heated zone exposes the first
sheeting to a maximum temperature of T_{MAX} , and the at least one roller is cooler
than T_{MAX} .

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15. The method of claim 13, wherein the nip is formed by two rollers.

16. The method of claim 15, wherein the two rollers are not actively heated.

30 17. The method of claim 13, wherein the at least one roller has a surface
hardness of about 60 to about 80 durometer.

18. The method of claim 13, further comprising:

providing a textured material; and

covering the cube corner elements of the first sheeting with the textured
material at least at the nip.

19. The method of claim 18, wherein an initial portion of the textured material
is passed through the extended heated zone before passing the cube corner
sheeting material through the extended heated zone.

20. The method of claim 18, wherein the extended heated zone exposes the first
sheeting to a maximum process temperature T_{MAX} , the method further
comprising:

pretreating the textured material by exposing it to a temperature higher
than T_{MAX} .